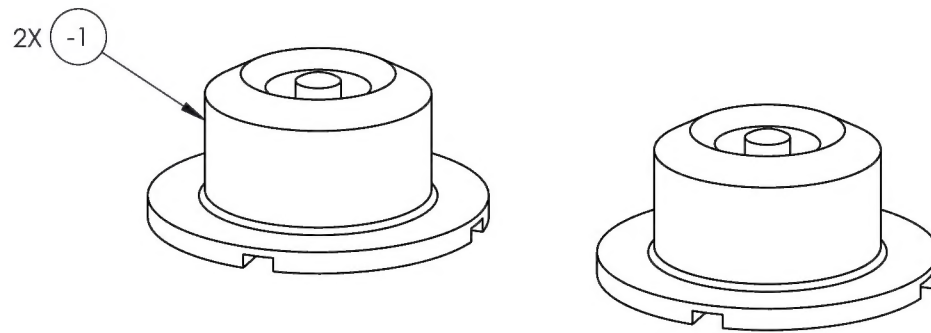


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	12/9/2016	DPD	JAG



NOTES:

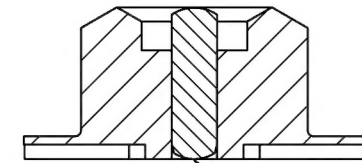
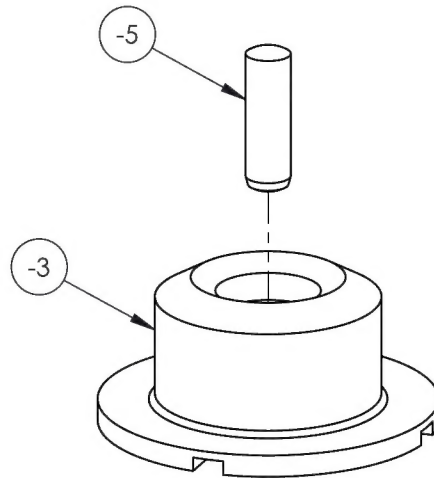
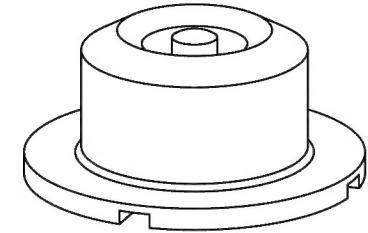
1. REF. AIRBUS T/N: 105-31781W6.
2. USED WITH RBE105-40001W1.
3. SUPERCEDES 105-31781W4.

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-31781W6	REV 1
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT PLAIN	.XXX ± .005 FRACTIONS ± 1/8
FINISH PLAIN	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145, EC645
SCALE 1:1	DATE 8/22/2016
SHEET 1 OF 3	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING ASSEMBLY			2
	1		-3		BASE	O1		3
	1	B/O	-5		DOWEL PIN	STEEL	M6 X 20mm (MCMaster-CARR #91595A452)	2
	ASSY -1							

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				



PRESS -5 DOWEL PIN
FLUSH TO BOTTOM
OF -3 BASE

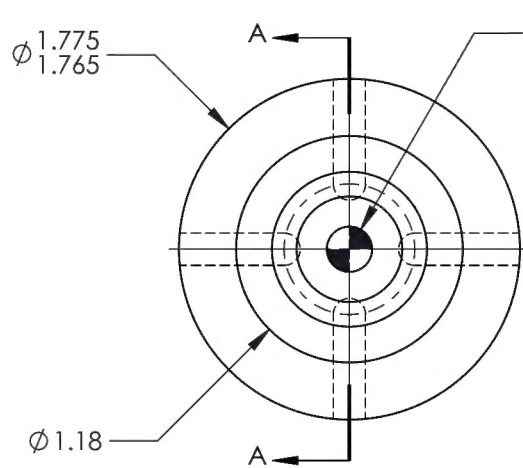
(-1)

STAKING ASSEMBLY

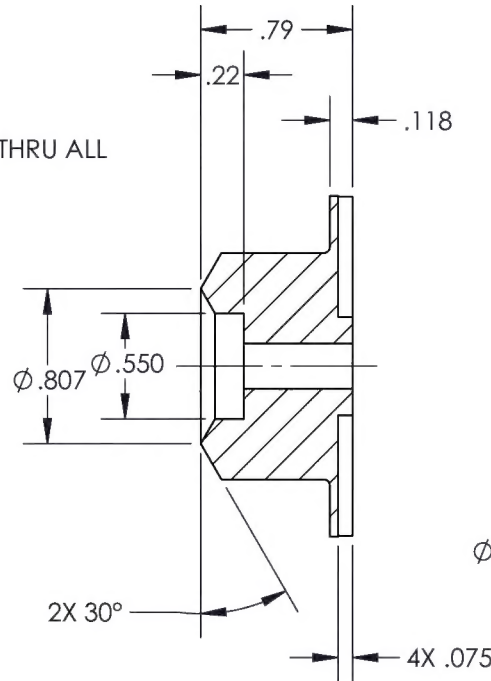
DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-31781W6-1	REV 1
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145, EC645
SCALE 1:1	DATE 8/22/2016
SHEET 2 OF 3	

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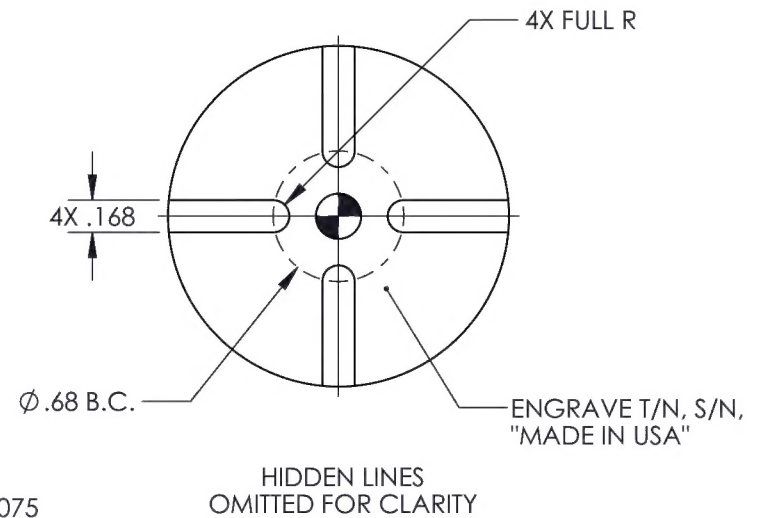
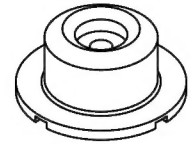
REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



$\phi .2362$
 $.2357$ THRU ALL
(P.F. -5)



SECTION A-A



(-3)

BASE

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-31781W6-3	REV 1
MAT'L O1 RC 50-60 TREAT FINISH SEE -1 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .005 FRACTIONS \pm 1/8 .XX \pm .01 ANGLES \pm .5° .X \pm .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145, EC645
SCALE 1:1	DATE 8/22/2016
SHEET 3 OF 3	